

Date: Monday, 02/06/2008 4:41:51 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CABIN DOOR ROLLER KIT, RH
Job Number :	39658		
Estimate Number :	10289		
P.O. Number :		Part Number :	D412698012
This Issue :	02/06/2008	Drawing Number :	IIN D412-698 REVD
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	39007	Material :	
Written By :		Due Date :	20/06/2008
Checked & Approved By :	JLD 08.6.02	Qty:	2
Comment :	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

S 08/06/12

JLD 08.6.04

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3121141	Bracket Assembly
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
3 D3121-141	Bracket Assembly	39013

AS 08/06/04

4.0	D3121144	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3121-144	Bracket Assembly	39015

AS 08/06/04

5.0	D3137043	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
		29725

AS 08/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:41:51 PM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 39658

Part Number: D412698012

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-044

Bracket Assembly

38444

SS 08/06/04 (X2)

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

36631

~~830~~ B39674 x 10

* New Batch

SS 08/06/04 (X2)

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

38445
~~35129~~

SS 08/06/04 (X2)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/06/12 (X2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location:

Rev B FG 62

SS 08/06/12 (X2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12

Job Completion



MF 08-06-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1			1			D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
			12				AN960JD10L	WASHER
		8					AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
		8					MS21042L4	NUT (OR MS21042-4)
		16					MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

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(CONTINUED FROM PAGE 14)

Qty -023	Part Number	Description
X	D412-698-023	AUTOMATIC DOOR OPENER KIT
1	D3552-11	GAS SPRING
1	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
1	D3594-044	FLOOR DOUBLER ASSMEBLY, RH
2	D3622-1	BALL STUD
2	AN960JD516L	WASHER

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